

Work Order ID 140448

140448

January 04, 2016 1:07:33 PM

Page 1

Item ID: D205-634-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Stop ***NS2***

Start Date: 1/4/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/18/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan: *SM*

Date: **20160104**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2580-041

G

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG005

N/A *MLJ* **FEB 24 2016**

110

110

CNC Bend 1

BENDING MACHINE - SKIDTUBES

0.00

Memo

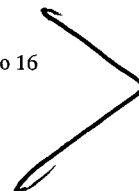
0.01

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube



16-1-6

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 Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH
 Start Date: 1/4/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Skidtubes	Memo	0.02							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for welding as per QSI 004								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

16-1-624

DAS
18
9-89

1 0 16-01-11

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Item ID: D205-634-041

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 1/4/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/18/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

140

Skidtubes

Memo

0.03

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod *M132917*

2-Grind welds on step as per Dwg D2580

3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start
expantion and finish with 1/2 x 18G to achieve dwg dimention.4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd
saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit
web.Deburr

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

150

QC10- Inspect visual per QSI004- ground welds 0.00

150

QC

Memo 0.00

Quality Control

38
9-89-89
JAN 13 2016

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Item ID: D205-634-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH
 Start Date: 1/4/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160						1			DAS 38 9-89
QC	Memo	0.00							JAN 14 2016
Quality Control									
170	Pressure Wash per QSI005 4.3	0.00							
170									
HandFinish	Memo	0.01							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.								
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180									
Powdercoat	Memo	0.01							
Powder Coating	START TIME: 3:25 OVEN TEMPERATURE: 300 FINISH TIME: 3:55								

1 Ø 16-1-13

1 Ø 160618, DAS 34 9-89

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Stop ***NS2***Start Date: 1/4/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/18/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89

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Item ID: D205-634-041

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Start Date: 1/4/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/18/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

HandFinish

0.03

Hand Finishing

Memo

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 11133862Sikaflex expire date: 16112

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024 RTU 598 11133346 1610 C

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 11133862Sikaflex expire date: 16112

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 111335761610216

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Item ID: D205-634-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH
 Start Date: 1/4/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
210									
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								FEB 18 2016
220		0.00							
220	Packaging								DAS 27 9-89
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-041								
	Location: _____								
	PPP Rev: _____								
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									MCS FEB 24 2016

PPP 141058

16/24

SA

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Work Order ID: 140448

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 1/4/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
 KJ IPP Rev P 10.02.19
 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS
 PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 *D4202-1* Spacer		Manufactured	No			140	Each	231.0000	20	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		231							
				134465		1							
				135848		1							
				136610		229							
D2580-1 *D2580-1* 205 Bent Tube		Manufactured	No			110	Each	4.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		4							
				138162		4							
D2576-3 *D2576-3* Step (Machining Detail)		Manufactured	No			140	Each	22.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		22							
				136730		22							

16-1-11 JH

20

16-1-6

1

BE 16-01-11

1

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Work Order ID: 140448

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 1/4/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200 Each

92.0000 1 1

D2855

Cap

**

all 1/6/01/19

Location

Loc Qty

Loc Code

FP001

92

10360

2

117281

2

134027

34

137568

54

X1

AN3-5A

Purchased No

200 Each

161.0000 2 2

AN3-5A

Bolt

**

all 1/6/01/19

Location

Loc Qty

Loc Code

FP001

30

m133686

30

X2

ST350

131

m133686

131

NAS1149D0332J

Purchased No

200 Each

1,277.000 2 2

NAS1149D0332.J

Washer

**

all 1/6/01/19

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

70

m129682

70

X2

GA

291

m132677

291

ST264

902

m133498

902

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Work Order ID: 140448

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 1/4/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

AELS8-1032-130 Purchased

No

200

Each

2,796.000

50

50

AI S7-1032-130

Rivnut

ll 16/01/19

Location

Loc Qty

Loc Code

FG

100

M128649

100

FP001

1357

M128649

1357

st549

1339

M128649

1339

x50

AN3C4A

Purchased

No

200

Each

565.0000

50

50

AN3C4A

Bolt

ll 16/01/26

Location

Loc Qty

Loc Code

FG

20

122814

20

FP001

533

M132317

76

M132551

61

M132803

50

M133440

346

ST349

12

M133234

12

M 134055

x40

x10

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 1/4/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

200

Each

2,850.000

50

50

NAS1149C0332R

WASHER

ll 16/01/26

Location

Loc Qty

Loc Code

FP001

1547

m132262

4

m132930

1004

m133284

539

GA

331

m133284

331

ST266

972

m133284

972

D3566-13

Manufactured

No

200

Each

20.0000

1

1

D3566-13

Gasket Fwd

ll 16/01/26

Location

Loc Qty

Loc Code

FG

4

92482

2

98908

2

FP001

16

137076

3

138176

13

D3566-5

Manufactured

No

200

Each

19.0000

1

1

D3566-5

Gasket Center Aft

ll 16/01/26

Location

Loc Qty

Loc Code

FG

2

94119

2

FP001

17

139236

17

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Work Order ID: 140448

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 1/4/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

D3566-1	Manufactured	No	200	Each	31.0000	2	2	
D3566-1								**
Gasket Aft / Fwd								all 16/01/20

Location	Loc Qty	Loc Code
FG	8	B140819
117012	4	
96430	2	
98981	2	
FP001	23	
138321	1	
139221	22	

D3564-11	Manufactured	No	200	Each	10.0000	1	1	
D3564-11								**
Wearplate Aft								B140820 (1x) all 16/02/16

Location	Loc Qty	Loc Code
FG	6	
77056	4	
85473	2	
FP002	4	
136463	4	

D3564-13	Manufactured	No	200	Each	9.0000	1	1	
D3564-13								**
Wearpad Fwd								all 16/01/20

Location	Loc Qty	Loc Code
FG	2	
89044	2	
FP001	7	
136628	1	
136629	6	

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Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 1/4/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

D3564-9

Manufactured No

200

Each

6.0000

1

1

D3564-9

Wearplate Fwd

all 16/01/26

Location

Loc Qty

Loc Code

FG

6

B137699

xl

76950

4

88407

2

D3564-5

Manufactured No

200

Each

10.0000

1

1

D3564-5

Wearplate Center

all 16/01/26

Location

Loc Qty

Loc Code

FG

3

34806

1

89048

2

FP002

7

136429

1

137634

6

D2594-3

Manufactured No

200

Each

504.0000

16

16

D2594-3

O-Ring

all 16/01/26

Location

Loc Qty

Loc Code

FP001

504

134838

116

135859

24

137829

130

138060

234

xl

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Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 1/4/2016

Required Date: 1/18/2016

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

351.0000

16

16

D2594-1

Plug

ll 160126

Location

Loc Qty

Loc Code

FP001

351

119830

68

134804

16

135914

33

136657

100

138397

100

42807

27

88922

7

116

LIST OF MATERIALS						PART NUMBER	DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047	QTY -049			
1	X					D2580-041	SKIDTUBE ASSEMBLY
2		X				D2580-045	SKIDTUBE ASSEMBLY
3			X			D2580-047	SKIDTUBE ASSEMBLY
4				X		D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16		D2570	BUSHING
22	1	1	1	1		D2576-3	STEP
23		4				D2579	SPACER
24	16	16	8	8		D2594-1	PLUG
25	16	16	8	8		D2594-3	O-RING
26	1	1	1	1		D2596	205 WEB
27	1	1	1	1		D2855	AFT CAP
28	1	1				D3564-5	WEARSHOE
29	1	1				D3564-9	WEARSHOE
30	1	1				D3564-11	WEARSHOE
31	1	1				D3564-13	WEARSHOE
32	2	2				D3566-1	GASKET
33	1	1				D3566-5	GASKET
34	1	1				D3566-13	GASKET
35	20	20	24	24		D4202-1	SPACER
36			1			D4406-041	WEARPLATE ASSEMBLY
37			1			D4406-043	WEARPLATE ASSEMBLY
37				1		D5061-1	FWD WEARPLATE
37				1		D5061-3	AFT WEARPLATE
50	50	50				ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50				AN3C4A	BOLT
52	2	2	2	2		AN3-5A	BOLT
53			8	8		AN4-45A	BOLT
54	50	50				NAS1149C0332R	WASHER (AN960C10L)
55	2	2	2	2		NAS1149D0332J	WASHER (AN960JD10L)
56			8	8		MS21042-4	NUT (OR MS21042L4)

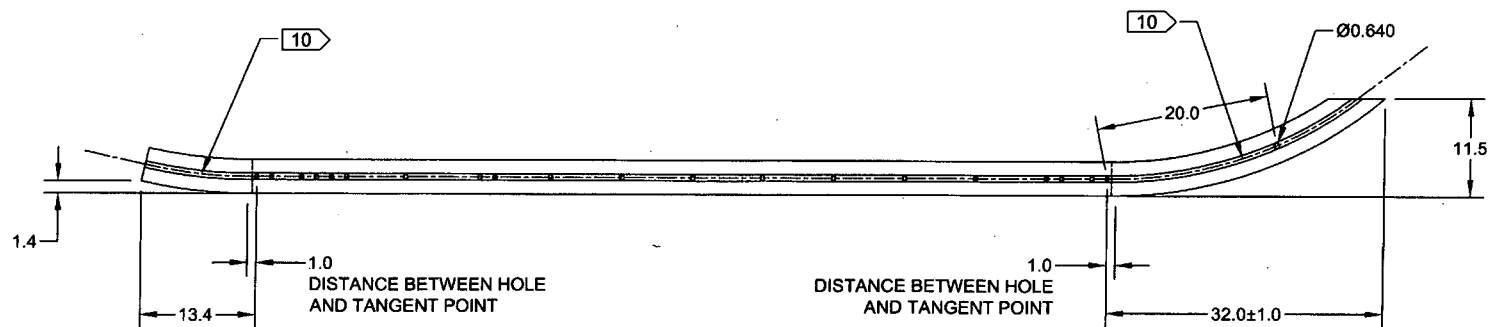
GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 POWDER COAT ASSEMBLY (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED
2014-04-29

20160104 SK 140498

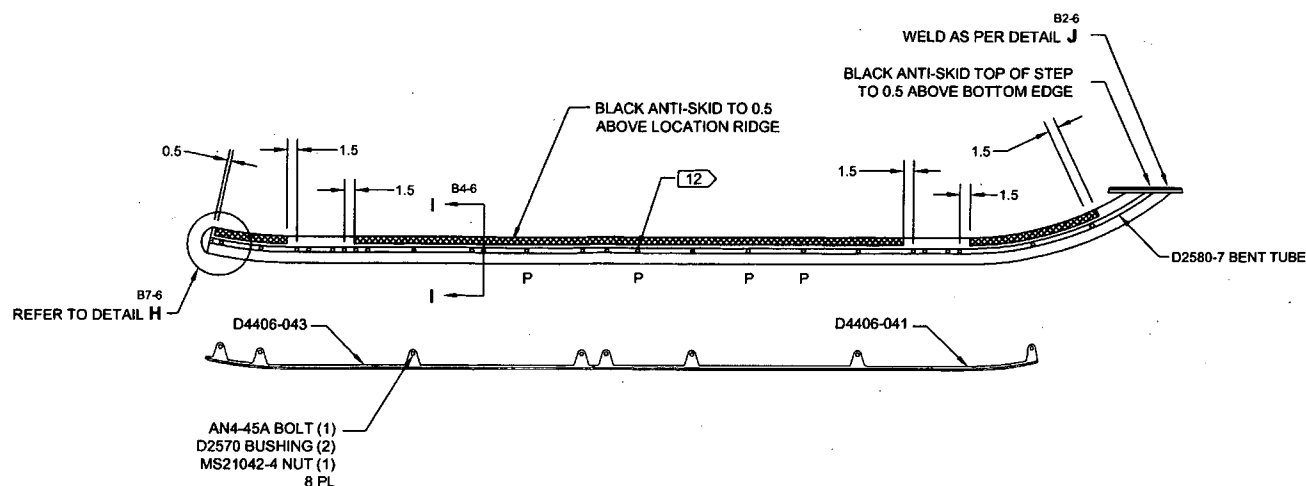
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	N	D2580	SHEET 1 OF 9
APPROVED	SK	TITLE	SCALE
DE APPR.	SK	205 SKIDTUBE ASSEMBLY	NTS
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

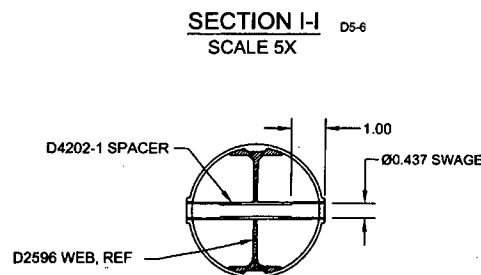
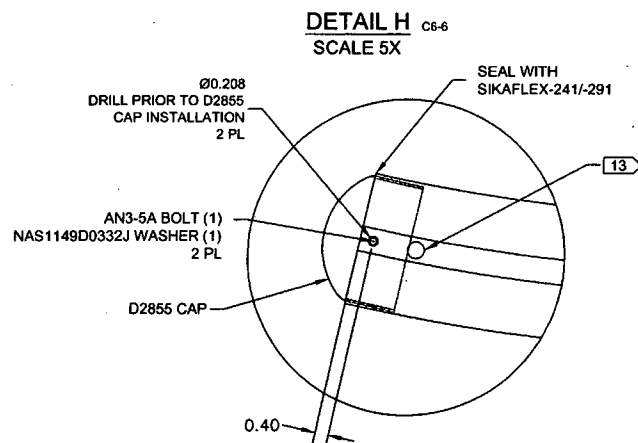
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DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 3 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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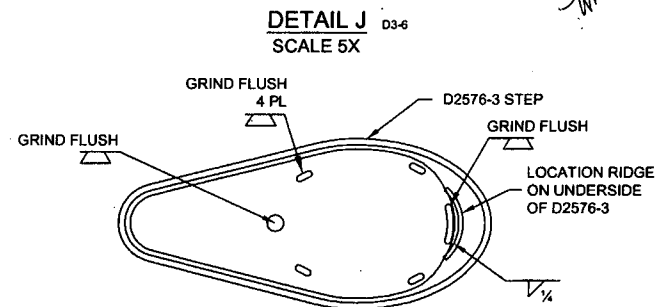


D2580-047 ASSEMBLY DETAIL

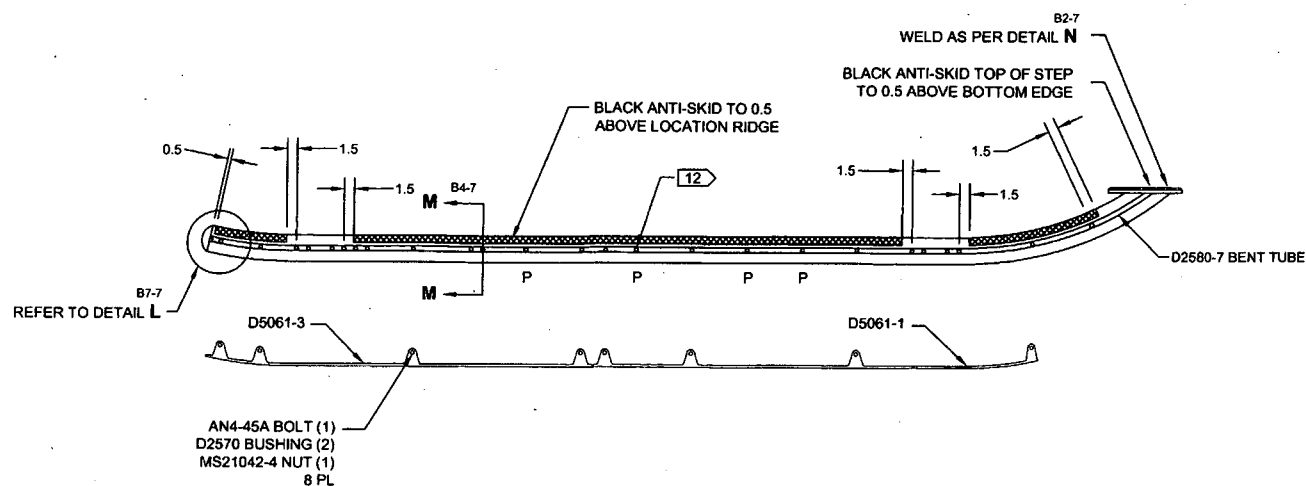
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2014-04-29



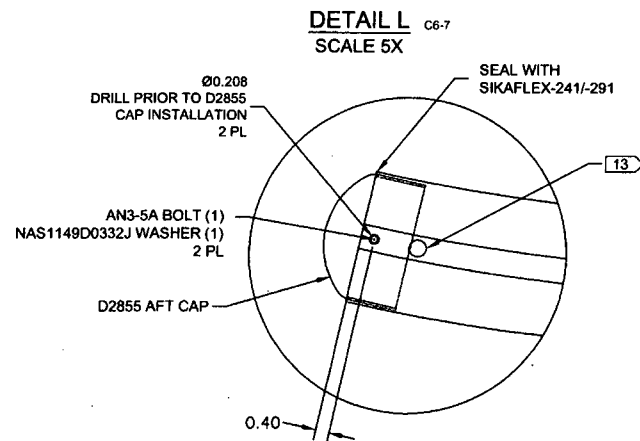
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



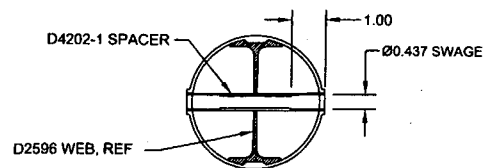
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>A.P.</i>	D2580	SHEET 6 OF 9
APPROVED	<i>A.P.</i>	TITLE	SCALE
DE APPR.	<i>A.P.</i>	205 SKIDTUBE ASSEMBLY	NTS
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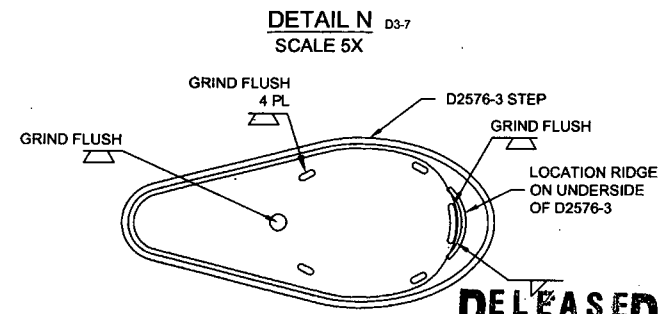
D2580-049 ASSEMBLY DETAIL



SECTION M-M D5-7
SCALE 5X

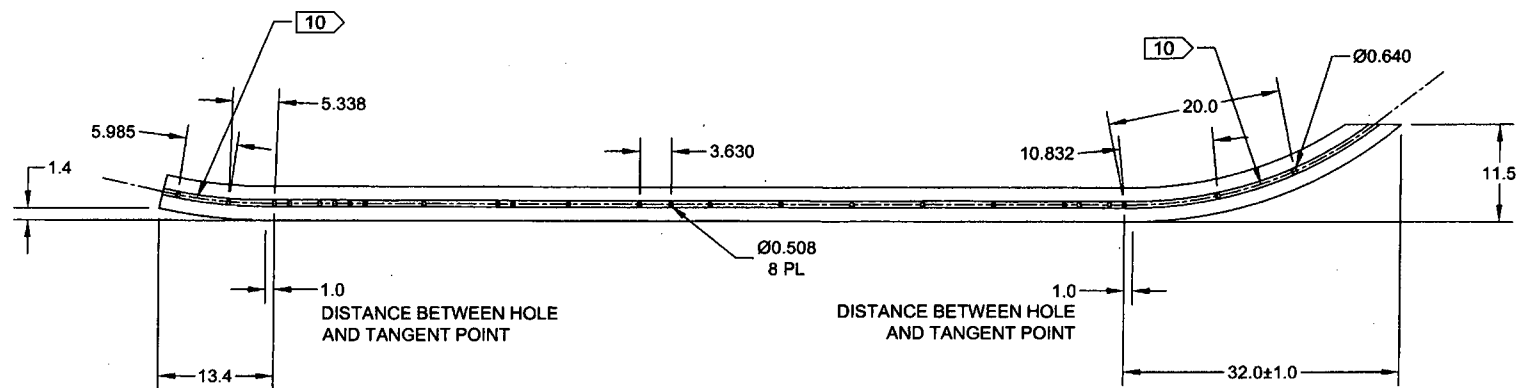


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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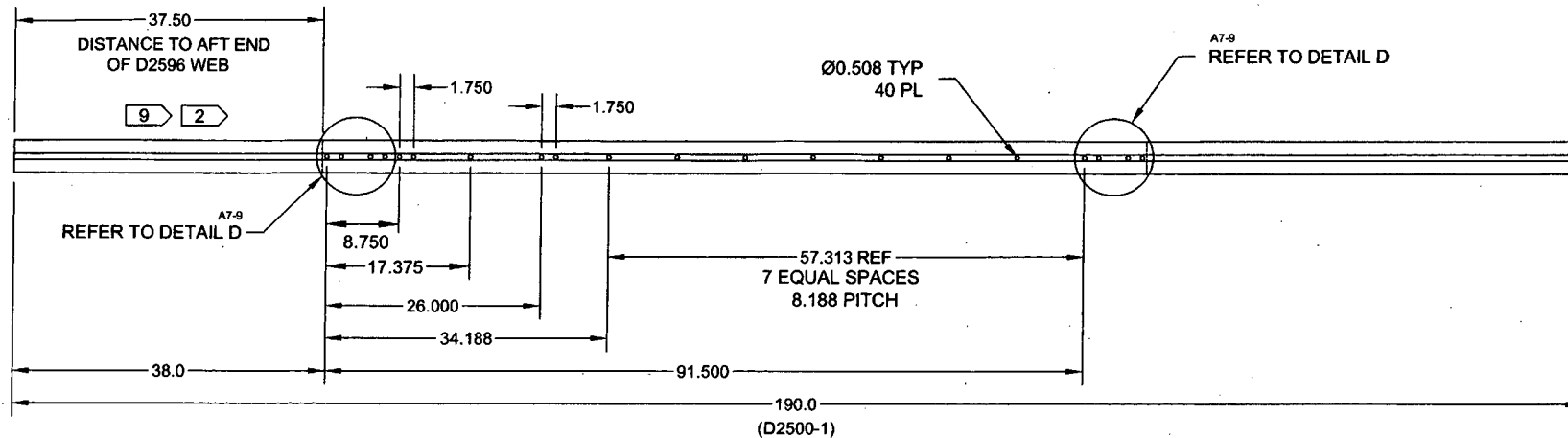
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 7 OF 9
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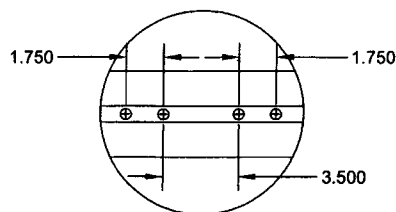
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2014-04-29

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CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 8 OF 9
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D2580-101 TUBE



DETAIL D
SCALE 5X
C3-9
C7-9

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WJD

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>M</i>	D2580	SHEET 9 OF 9
APPROVED	<i>WJD</i>	TITLE	SCALE
DE APPR.	<i>WJD</i>	205 SKIDTUBE ASSEMBLY	NTS
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